

Date: Monday, 23/03/2009 11:13:13 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-----------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | PILOT/CO-PILOT STEP, RH (FOLDING) |
| Job Number : | 46662 | | |
| Estimate Number : | 10824 | | |
| P.O. Number : | | Part Number : | D412630032 |
| This Issue : | 23/03/2009 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | IIN D412-630 |
| First Issue : | / / | Project Number : | N/A |
| Previous Run : | 46122 | Drawing Revision : | M |
| Written By : | | Material : | |
| Checked & Approved By : | | Due Date : | 26/03/2009 |
| Comment : | EST. REV. A 05.11.21 NEW ISSUE EC EST. REV. B 05.12.19 updated pick list EC EST. REV. C 07.11.12 ecn 1019, nochg EC verified by: DD Est Rev: D 09-03-02 as per rev. m DD verified by: ec | | |

Qty: 2 Um: Each

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-032

CHG001

| | | |
|-----|----------|------------------------|
| 2.0 | D3463042 | Step Weldment Assembly |
|-----|----------|------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------|--------|
| 1 | D3463-042 | Step weldment | B46123 |

| | | |
|-----|----------|-------------------------|
| 3.0 | D3443043 | Strut Weldment Assembly |
|-----|----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D3443-043 | Strut ass'y | 46130 |

| | | |
|-----|----------|-------------------------|
| 4.0 | D3443041 | Strut Weldment Assembly |
|-----|----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D3443-041 | Strut ass'y | 46127 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 11:13:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46662

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

~~D34439~~

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------------|-------------|-------|
| 2 | D3443-9 | Pin | 46131 |

sq

6.0

~~AN4GH3~~

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 2 | AN4CH3 | BOLT | M410665 |
| A/R | MS20995c41e | Lockwire | M4101537 |

2
M411176

sq

7.0

~~D34547~~

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | D3454-7 | Bushing | B44589 |

sq

8.0

~~AN3104~~

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------------|-------------|----------|
| 2 | AN310-4 | Nut | M4111060 |

sq

9.0

~~MS24665227~~

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 1 | MS24665-227 | COTTER PIN | M4109174 |

91363

sq

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46662

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

~~034551~~

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------------|-------------|------------------|
| 2 | 034551 | Spacer | 11633 |

SP

11.0

~~034651~~

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------------|-------------|---------------------|
| 1 | 034651 | Washer | 13916972 |

SP

12.0

~~AN3107~~

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------------|-------------|--------------------|
| 1 | AN3107 | Nut | 1103286 |

SP

13.0

~~MS24665302~~

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-----------------------|-------------|--------------------|
| 1 | MS24665302 | COTTER PIN | 1106763 |

SP

14.0

~~AN4G14~~

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------------|-------------|--------------------|
| 1 | AN4G14 | BOLT | 1110552 |

9/3/23

SP

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46662

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

9/3/25 (2)

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

8 09/03/25 +2 R4

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0 D34541 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D3454-1 | Bushing | 4635 |

SP

19.0 D34543 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | D3454-3 | Bushing | 46136 |

SP

20.0 D34545 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | D3454-5 | Bushing | 46133 |

SP

46137

9/3/24

(24)

SP

Date: Monday, 23/03/2009 11:13:13 AM
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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46662

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D34551

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
4 D3455-1 Spacer

Batch

B46133

SP

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D3455-3 Spacer

Batch

B46139

SP

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description
1 D3462-042 Bracket ass'y

Batch

B46141

SP

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description
1 AN310-4 Nut

Batch

M111060

SP

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 AN310-5 Nut

Batch

M110552

9/3/24

SP

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46662

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-C5A Bolt

Batch M110985

SP

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN44-C12 Eyebolt

Batch M110342

SP

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C15 BOLT

Batch M110155

SP

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C11 BOLT

Batch M1103248

SP

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C15 BOLT

Batch M110155

9/3/23

SP

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46662

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 7.0000 EACH(s)

Pick:

Qty Part Number Description Batch
7 AN960C10 Washer M109165

S @

SP

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960C516 Washer M102842

S @

SP

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS21043-3 Nut M110562

S @

SP

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-227 COTTER PIN M109174

S @

SP

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-229 COTTER PIN M109174

S @

9/2/23

SP

Date: Monday, 23/03/2009 11:13:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46662

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

NAS1515H5

Washer



(2x)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

M109430 9/13/23

510

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808/03/25 (2RH)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



(5x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-032

Location:

PPP Rev:

31
B

9/13/25

50

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25/1A

Job Completion



-mf
09-03-25

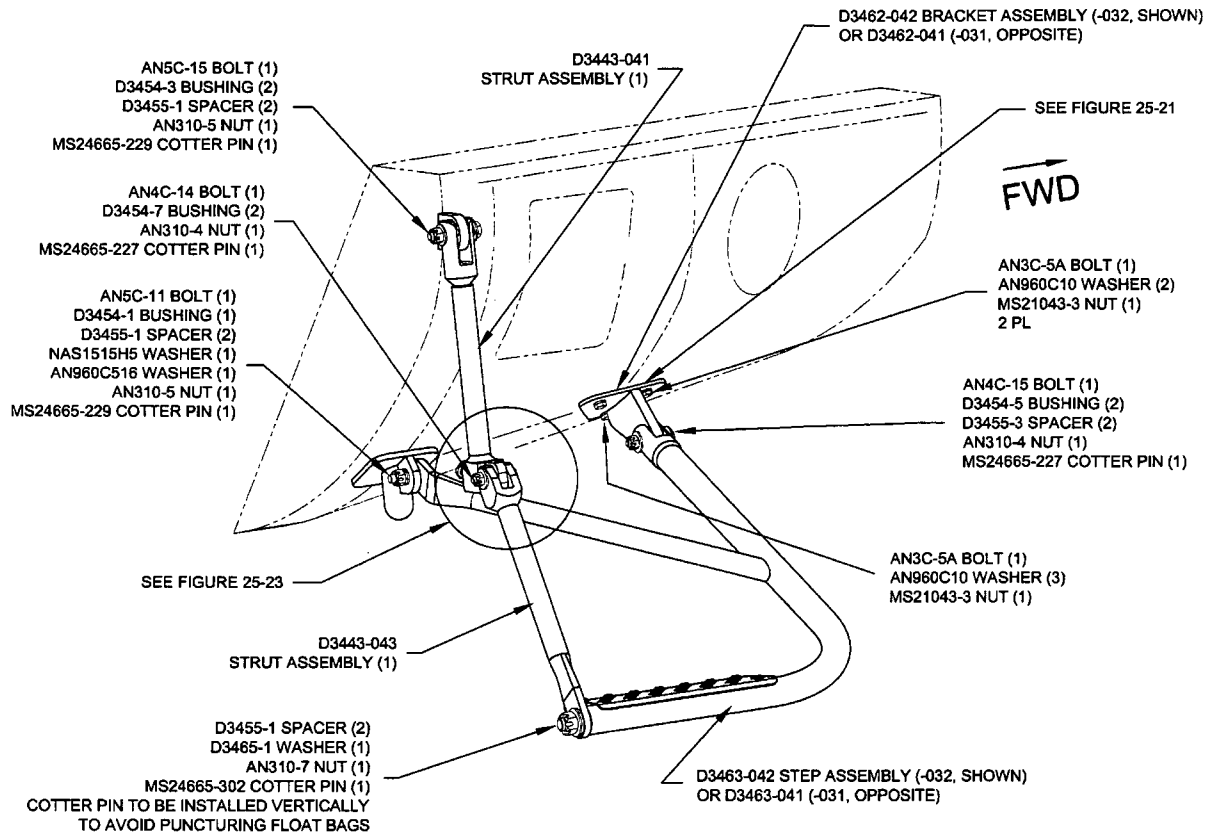


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

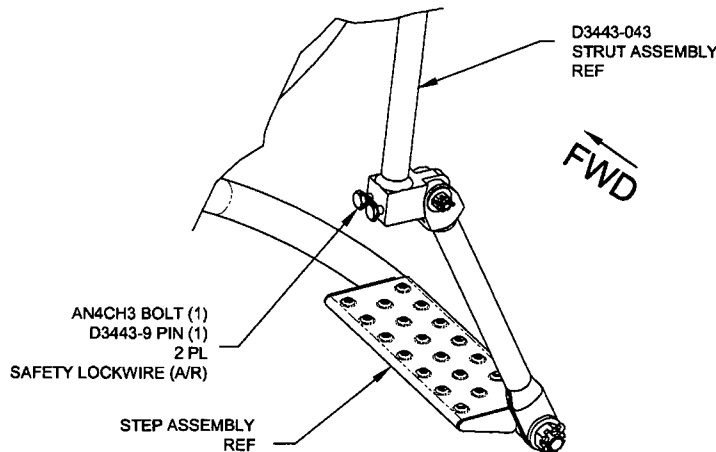


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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